

# Work Order ID 75323

**\*75323\***

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Item ID: D206-628-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Heli-Access-Step LH  
 Start Date: 20/10/2011 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 02/11/2011 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-011 CHG 003

*8 11/10/26*

*After M.L.S 11-10-25 P.D. →*

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

*SP 11-10-26.*

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*8 11/10/26*

*42  
44*

W/O: 75323

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-628-011 PAR #: N/A Fault Category: Production/Eng NCR: Yes No DQA: 1 Date: 11.10.28  
 Resolution: Rework Disposition: rework QA: N/C Closed: 1 Date: 11/10/31

NCR: 11-938

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/02/25	#100	Wrong parts on P.C. list. R.C. w/o + Bom are incorrect w/o	UP 11/10/27 OS/042	Remove from list D 3394-041 + D27313 Fix Bom + <del>add</del> w/o	11-10-27	11/10/28	UP 11.10.27 OS/042	S 11/10/25
			UP 11.10.27 OS/042	ADD copy of new Bom for Ref.	11.10.27		UP 11.10.27 OS/042	S 11/10/25

NOTE: Date &amp; initial all entries

# Work Order ID 75323

**\*75323\***

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October-20-11 2:55:26 PM

Item ID: D206-628-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step LH

Start Date: 20/10/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-011 Location: <u>71</u> PPP Rev: <u>P</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*Sp 11-10-26 (2)*

*11/10/27 MF 11-10-26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 75323

\*75323\*

Parent Item: D206-628-011

\*D206-628-011\*

Parent Item Name: Heli-Access-Step LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM  
IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-13A		Purchased	No			120	Each	1,136.000	4	8			
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\*AN4-13A\*

Bolt

Location

Loc Qty

Loc Code

ST357

1136

118078

590

118706

46

118838

500

AN4-14A		Purchased	No			120	Each	263.0000	4	8			
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\*AN4-14A\*

Bolt

Location

Loc Qty

Loc Code

ST357

263

118628

100

118706

63

119127

100

AN4-15A		Purchased	No			120	Each	567.0000	4	8			
---------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

\*AN4-15A\*

Bolt

Location

Loc Qty

Loc Code

ST358

567

118112

4

118648

263

118706

200

119127

100

AN960JD416	NAS1149D0463J	Purchased	No			120	Each	0.0000	12	24			
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\*AN960.ID416\*

Washer

m119042

SP. 11-10-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 75323

**\*75323\***

Parent Item: D206-628-011

**\*D206-628-011\***

Parent Item Name: Heli-Access-Step LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 2.00

Required Qty: 2.00

D2721-041

Manufactured No

120

Each

0.0000

2

**\*D2721-041\***

206B Step Assembly

D2731-3

Manufactured No

120

Each

28.0000

2 4

**\*D2731-3\***

Mounting Lug

Location

Loc Qty

Loc Code

ST469

28

47967

5

52329

23

Manufactured No

120

Each

48.0000

2 4

D2731-7

**\*D2731-7\***

Mounting Lug

Location

Loc Qty

Loc Code

ST468A

48

71860

48

Manufactured No

120

Each

4.0000

8 16

D2732-030

**\*D2732-030\***

Rubber Cushion

Location

Loc Qty

Loc Code

ST409

4

56515

0

64283

4

Manufactured No

120

Each

34.0000

2 4

D3394-041

**\*D3394-041\***

Lug Assembly

Location

Loc Qty

Loc Code

ST474

34

73418

34

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

October-20-11 2:55:31 PM

Work Order ID: 75323

**\*75323\***

**\*D206-628-011\***

Parent Item: D206-628-011

Parent Item Name: Heli-Access-Step LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 2.00

Required Qty: 2.00

D3394-043

Manufactured No

120

Each

21.0000

\*\*

**\*D3394-043\***

Lug Assembly

Location

Loc Qty

Loc Code

ST475

21

62930

1

66429

20

Purchased

No

120

Each

13,966.00

\*\*

MS21042L4

**\*MS21042L4\***

Nut

Location

Loc Qty

Loc Code

ST300

2966

117441

51

117601

537

118451

1378

118927

1000

ST516

6000

119017

6000

ST518

5000

119075

5000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# 5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

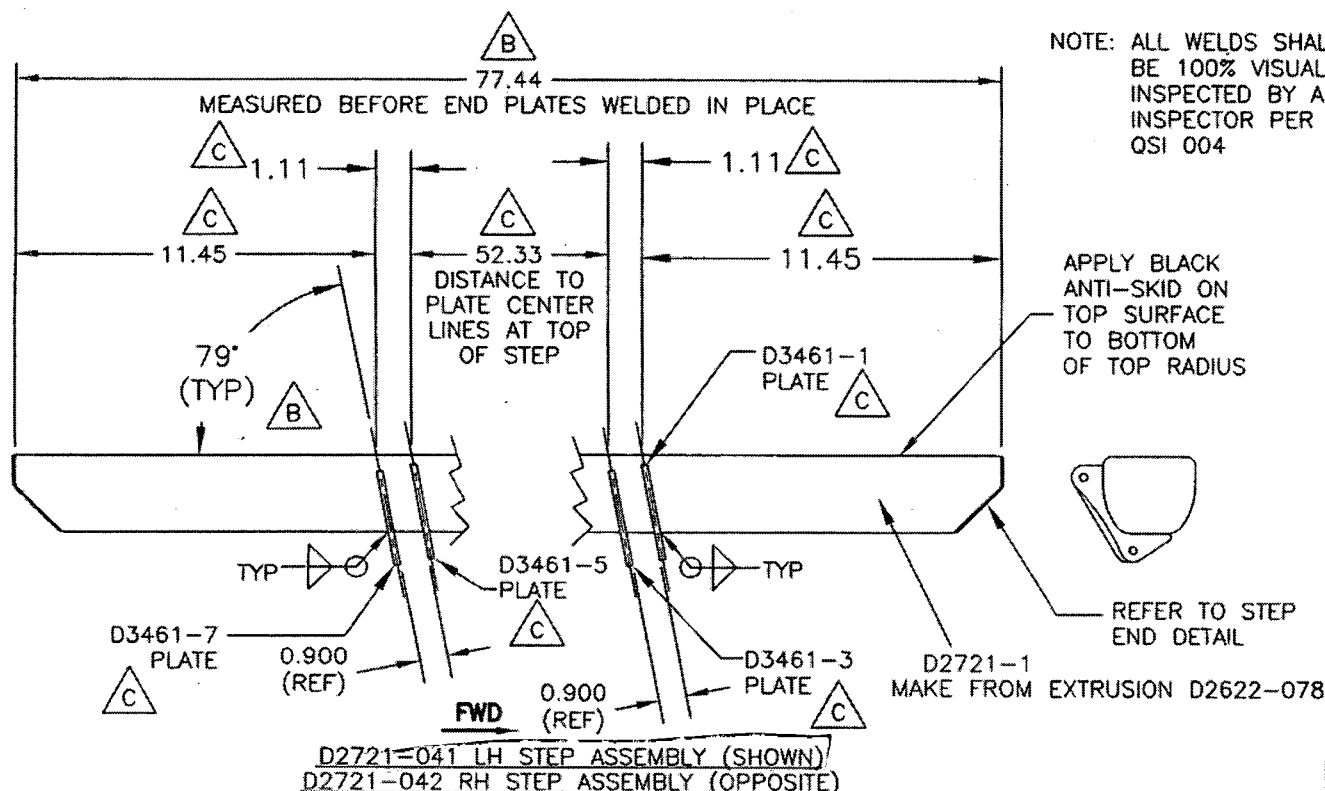
\*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

REFERENCE ONLY

**DART**

RELEASED  
05.11.14

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004



D2721-041 LH STEP ASSEMBLY (SHOWN)  
D2721-042 RH STEP ASSEMBLY (OPPOSITE)

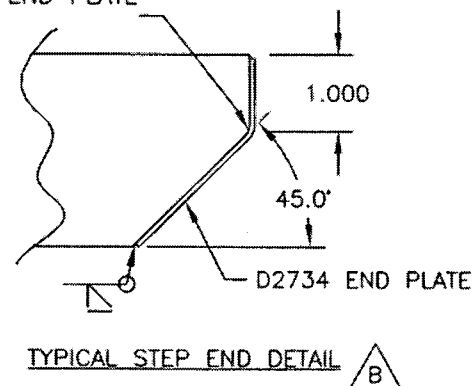
ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE

#### D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2721-041	LH STEP ASSEMBLY
		D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

#### D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
PH	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D2721
DATE	TITLE	REV. C
05.09.19	206B STEP ASSEMBLY	SHEET 1 OF 1
	NEW ISSUE	SCALE
		NTS
		RE-DESIGN, ADD D3461-1/-3/-5/-7
		79° WAS 80°, UPDATED WELD DETAIL REVISED TOLERANCES, 53.44 WAS 54.0